

Work Order ID 163561

Wednesday, June 28, 2017 3:39:01 PM

***163561***

Page 1

Item ID: D4941-1L08 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Floor Protector, Fwd LH, (Clear)
Start Date: 7/5/2017 **Start Qty:** 5.00 ***5*** **Cust Item ID:**
Required Date: 7/12/2017 **Req'd Qty:** 5.00 ***5*** **Customer:**
Reference:

Approvals: **Process Plan:**  **Date:** JUN 28 2017 **Tooling:** **Date:** **Run Start** ***NR1***
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4941	D								
110	THERMOFORMING MACHINE	0.00							
110									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: 37041								
	SUPPLIER: PLASTECH								
	MANUFACTURE D4941-1L08 AS PER DWG								
	C OF C IS REQUIRED								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140	HAND FINISHING THERMOFORMING								
Packaging	Memo	0.00							
Packaging									

DAS
13
9-88

LAB 17/07/13

5x SP 17-9-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

am 17/9/20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, June 28, 2017 3:39:01 PM

Page 1

Work Order ID: 163561

163561

Parent Item: D4941-1L08

D4941-1L 08

Parent Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 7/5/2017

Required Date: 7/12/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL
DL
Verify DD
IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev D Revised Dwg. 14/07/25
IPP Rev.E 17.06.13 Now outside process DP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4941-1L08P		Purchased	No			110	Each	0.0000	1	5			
D4941-1L 08P									**				
Floor Protector, Fwd LH, (Clear)													
MLEXS.118-90318-08		Purchased	No			110	sf	194.5690	4.875	24.375			
MI FXS 118-90318-08									**				
Lexan Sheet (Clear)													

Location

RM

m126994

M138294

Loc Qty

194.56897

194.56897

Loc Code

5x 8017-9-12

SEP 21 2017

172220

DQA: _____ Date: _____

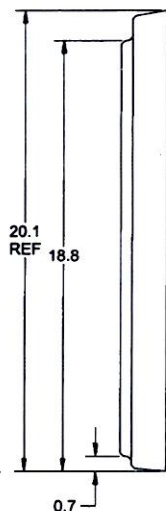


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

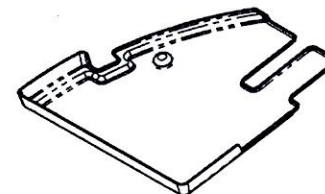
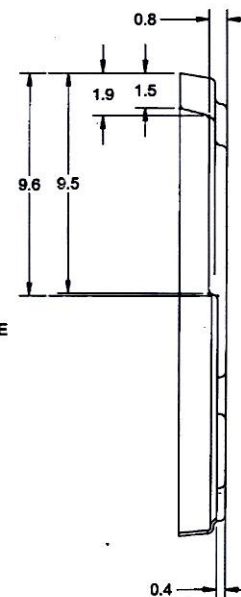
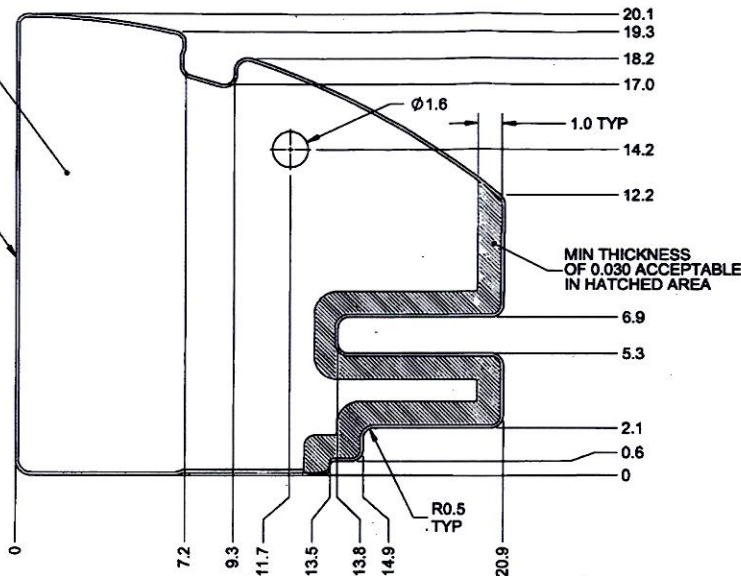
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														



TEXTURED SURFACE
ON THIS SIDE

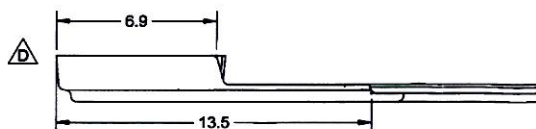
6



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163584-2

JUN 28 2017

RELEASED
2014-10-08
MD



D4941-1LXX FWD LH FLOOR PROTECTOR

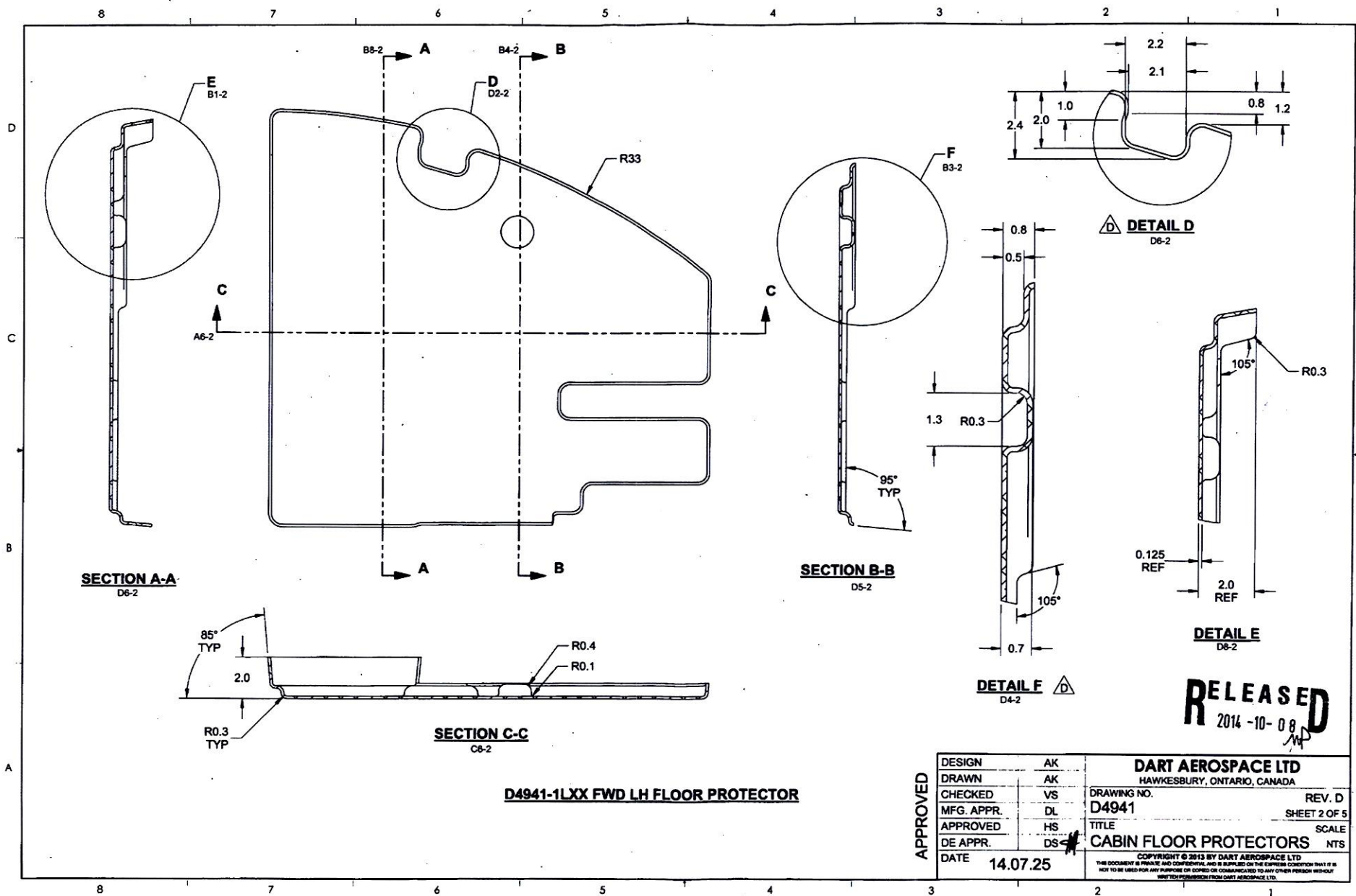
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 1.5 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9990
TRIM PER MOLD LEAVING FINISHED EDGES
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-1L02	F8006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F8006-02)
D4941-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

D	ADDED VIEWS (ZN C3-1, ZN D6-1, ZN A6-1), EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2), EDITED TRIM LOCATION ON D4941-2 (ZN B6-3), EDITED VIEW (ZN D6-3), ADDED VIEW (ZN A6-3), ADDED DETAIL H (ZN C2-3), REVISED D4941-3 AND D4941-4.	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D6-2, ZN D6-2, ZN D2-2, ZN C1-2), ADDED A CUTOUT TO D4941-2LXX (ZN B6-3), REVISED D4941-4 TO REMOVE CUTOUT (ZN B6-3).	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-11-21-3/4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4941 TITLE CABIN FLOOR PROTECTORS SCALE NTS DATE 14.07.25 COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS	REV. D SHEET 1 OF 5	

APPROVED



D4941-1LXX FWD LH FLOOR PROTECTOR

APPROVED

DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	DL	D4941	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CABIN FLOOR PROTECTORS	NTS
DATE	14.07.25	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-10-08



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37041**

Purchase Order Date 7/13/2017

PO Print Date 7/14/2017

Page Number 1 of 3

Order From :
PLAS-TECH
115 APPLEWOOD CRESCENT
CONCORD, ONTARIO L4K 5C1

VC-PLT01

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JUL 17 2017

Contact Name
Vendor Phone 416-736-0004

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer Diane Baker
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4941-1L08P As per dwg D4941 REV. D B163561 	Floor Protector, Fwd LH, (Clear)	8/3/2017 Yes 8/3/2017		5.00 Each	\$105.00	\$525.00
Line Total:							\$525.00
2	D4941-2L08P As per dwg D4941 REV. D B163560	Floor Protector, Fwd RH, (Clear)	8/3/2017 Yes 8/3/2017		5.00 Each	\$105.00	\$525.00
Line Total:							\$525.00

SPA-9-12

Note:

7/14/2017

Packing Slip



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Shipment Number: 24292
Shipment Date: 09/08/2017
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: ROBERT ABOUD
O Buyer Contact: ROBERT ABOUD

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: ROBERT ABOUD
O

Purchase Order
37041
Carrier Account #

Sales Order
SO-019295

Incoterms
EX WORKS

Payment Method
PPD/CHG
Tracking Number

Ship Via
FREIGHTCOM INC. -

Item Number - Revision Description

Quantity UOM
Shipped

D4941-1L08 - Rev.: D	CABIN FLOOR PROTECTORS	
	HS Code: 3920.61.1000 - OTHER	Country of Origin : CA
D4941-2L08 - Rev.: D	CABIN FLOOR PROTECTORS	
	HS Code: 3920.61 1000 - OTHER	Country of Origin : CA
D4941-3L08 - Rev.: D	CABIN FLOOR PROTECTORS	
	HS Code: 3920.61 1000 - OTHER	Country of Origin : CA
D4941-4L08 - Rev.: D	CABIN FLOOR PROTECTORS	
	HS Code: 3920.61.1000 - OTHER	Country of Origin : CA

5 EA

5 EA

5 EA

5 EA

SP17-9-12.

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 37041 SO # 019295

Part #	D4941-1L08	Qty.	5	Batch #	-001
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-2L08	Qty.	5	Batch #	-002
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-3L08	Qty.	5	Batch #	-003
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #	D4941-4L08	Qty.	5	Batch #	-004
Description	CABIN FLOOR PROTECTORS	Material usage	1 SHEET	Lot#	M138294
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: BRUCE QUAN Date: SEPT. 7, 2017 COFC# 011
(Approved QA Signatory)

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

DART AEROSPACE LTD		Work Order:	
Description: Floor Protector, LH Fwd		Part Number:	D4941-1L02/L08
Inspection Dwg: D4941	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DAS
07
9-89
Date: 17/09/14

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0	+/-0.100	2.01"	✓			
0.8	+/-0.100	0.83"	✓			
0.4	+/-0.100	0.42"	✓			
6.9	+/-0.100	6.9"	✓			
13.5	+/-0.100	13.5"	✓			
7.2	+/-0.100	7.2"	✓			
20.1	+/-0.100	20.1"	✓			
20.9	+/-0.100	20.9"	✓			
0.070	Min	0.090"	✓			
0.030	Min	0.033"	✓			

Measured by: DAS
07
9-89
Date: 17/09/14

Audited by: PD
Date: 12.09.20

Preliminary Approval: _____
 Date: _____

Rev	Date	Change	Revised By	Approved
A	15.04.27	New Issue	KJ	

Inspection Checklist

COPY

PLAS-TECH
Think Plastics™

Customer: Dart Aerospace Ltd

SO # 019295-001

Description: Floor Protector, LH Fwd

Part #: D4941-1L02/L08

Inspection Dwg: D4941

Rev: D

Page: 1 of 1

Inspection Checklist: ☐ First Article

☐ Prototype

☒ First Off

Thermoforming Section

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratches	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Trimming Section

Drawing Dim.	Tolerance	Actual Dimensions	Accept	Reject	Method of Inspection	Comments
2.0	+/- 0.100	2.03	✓			
0.8	+/- 0.100	0.89	✓			
0.4	+/- 0.100	0.49	✓			
6.9	+/- 0.100	6.87	✓			
13.5	+/- 0.100	13.5	✓			
7.2	+/- 0.100	7.18	✓			
20.1	+/- 0.100	20.09	✓			
20.9	+/- 0.100	20.9	✓			
0.070	Min	N/A				
0.030	Min	0.040	✓			

Measured by: BRUCE QUAN

Date: SEPT. 7, 2017

Approval by: _____

Date: _____

Rev.	Date	Change	Revised by	Approved